

Wednesday, April 23, 2014 1:16:31 PM

Page 1

Cust Item ID:
Customer:

Run	Start	*NR1*
	Stop	*NR2*

Draw Nbr	Revision Nbr
DSI 9681	A

1 14-05-26

53 chg 001

Photocopy bluefile and create labels as per PPP D412-761-053 chg 001

0.00

1 DAS
32 14-04-30
9.80

0.00

DAS 31
27 9-88
9-88
14/5/26

1 14-05-26

Work Order ID 116704

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116704

Page 2

Item ID: D412-761-053 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: U/R Stop ***NS2***
Item Name: Door Mounted Instrument Panel, LH
Start Date: 4/23/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/30/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-761-053 Location: <u>FG 630</u> PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

CHG001 17/4/40

POSITIVE RECALLEFFECTIVE 14-05-26 AUTH LLRELEASED 9 DATE 17-04-04

9-89

@ CHG001

DAS
21
9-89

APR 23 2014

Picklist Print

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Page 1

Work Order ID: 116704

116704

Parent Item: D412-761-053

D412-761-053

Parent Item Name: Door Mounted Instrument Panel, LH

Start Date: 4/23/2014

Required Date: 4/30/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.01.09 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5023-041 *D5023-041* Instrument Panel Assembly		Manufactured	No				Each	0.0000		1		DAS 28 9-89	
AN3-3A *AN3-3A* Bolt		Purchased	No				Each	393.0000		2		DAS 33 9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST350				393					
				m126249				1					
				m127815				142					
				m128429				250					
AN3-4A *AN3-4A* Bolt		Purchased	No				Each	452.0000		8		DAS 33 9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST350				404					
				m128429				100					
				m128634				4					
				m128739				300					
				ST511				48					
				m127044				48					
AN743-12 *AN743-12* Clip		Purchased	No				Each	35.0000		1		DAS 33 9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST347				35					
				M126175				10					
				M127124				25					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____ _____
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Picklist Print

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Page 2

Work Order ID: 116704

Parent Item: D412-761-053

Parent Item Name: Door Mounted Instrument Panel, LH

116704

D412-761-053

Start Date: 4/23/2014

Required Date: 4/30/2014

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

Each

8,145.000

10

MS21042L3

Nut

**

DAS
33
9-89

DAS
31
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST314

1190

M127410

149

M127831

41

M128401

1000

ST506

955

123900

955

ST509

6000

M128754

6000

Each

667.0000

1

MS21919-WDG8

Purchased

No

MS21919-WDG8

Clamp

**

DAS
33
9-89

DAS
31
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

MF4

667

123900

17

m127916

1

m128057

649

Each

5,664.000

10

NAS1149D0332J

Purchased

No

NAS1149D0332J

Washer

**

DAS
33
9-89

DAS
31
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST294

664

m128606

664

ST510a

5000

m128612

5000

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 116704

Parent Item: D412-761-053

Parent Item Name: Door Mounted Instrument Panel, LH

116704

D412-761-053

Start Date: 4/23/2014

Required Date: 4/30/2014

Start Qty: 1.00

Required Qty: 1.00

AN526C1032R6

Purchased

No

Each

461.0000

6

AN526C1032R6

Screw

DAS
31
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST346

461

1892

461

Each

3.0000

1892

1

**

DAS
33
9-89

D3867-1

Manufactured

No

D3867-1

Connector Plate

DAS
31
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST067

3

103733

3

Each

10.0000

1

**

DAS
33
9-89

D3705-7

Manufactured

No

D3705-7

Main Panel

DAS
31
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST062

10

105314

10

Each

6.0000

1

**

DAS
33
9-89

D3705-9

Manufactured

No

D3705-9

Panel

DAS
31
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST062

6

110932

6

110932

14-04-36

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 116704

116704

Parent Item: D412-761-053

D412-761-053

Parent Item Name: Door Mounted Instrument Panel, LH

Start Date: 4/23/2014

Required Date: 4/30/2014

Start Qty: 1.00

Required Qty: 1.00

D3705-11

Manufactured No

Each 5.0000

D3705-11

Main Panel

**

DAS
31
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST062

5

103765

3

106899

2

Each 14.0000

D4758-1

Manufactured No

D4758-1

Blanking Plate

**

DAS
31
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST122

14

105692

4

107497

8

98103

2

Each 5.0000

D4758-3

Manufactured No

D4758-3

Blanking Plate

**

DAS
31
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST122

5

106794

5

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-761 REV. E OR EARLIER AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-761 REV 2 OR EARLIER

REF TCCA STC: SH09-4
REF. EASA STC: 10028917

PURPOSE

THE PURPOSE OF THIS SERVICE INSTRUCTION IS TO ADD THE ALTERNATE D412-761-053 INSTRUMENT PANEL KIT IN LIEU OF D412-761-047. IT IS DESIGNED FOR INSTALLATION IN A LH DOOR MODIFIED WITH A FULL VERTICAL REFERENCE WINDOW. THE KIT CONSISTS OF AN INSTRUMENT PANEL ASSEMBLY DESIGNED WITH THE READING/ WORKING FACE FIXED AT A 12 DEGREE ANGLE TO THE HORIZONTAL.

INSTALLATION

THE D412-761-053 INSTRUMENT PANEL INSTALLATION KIT SHOULD BE INSTALLED ON THE AIRCRAFT PER INSTALLATION DRAWING D412-761-5.

WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-761-053 Door Mounted Instrument Panel Kit (Excludes Instruments)	4.0 lb 1.82 kg	-42.8 in -1.09 m	-171.2 lb-in -1.98 kg-m	39.2 in 1.00 m	156.8 lb-in 1.82 kg-m

PARTS LIST

QTY -053	P/N	DESCRIPTION
X	D412-761-053	DOOR MOUNTED INSTRUMENT PANEL KIT
1	D5023-041 ✓	INSTRUMENT PANEL ASSEMBLY
2	AN3-3A ✓	BOLT
8	AN3-4A ✓	BOLT
1	AN743-12 ✓	BRACKET, SUPPORT CLAMP
10	MS21042L3 ✓	NUT
1	MS21919WDG8 ✓	SUPPORT CLAMP
10	NAS1149D0332J ✓	WASHER (AN960JD10L)
6	AN526C1032R6 ✓	SCREW
1	D3867-1 ✓	CONNECTOR PLATE
1	D3705-7 ✓	FACE PLATE
1	D3705-9 ✓	FACE PLATE
1	D3705-11 ✓	FACE PLATE
2	D4758-1 ✓	BLANKING PLATE
3	D4758-3 ✓	BLANKING PLATE

MAINTENANCE

MAINTAIN THE D412-761-053 KIT PER THE INSTRUCTIONS PROVIDED IN INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-761 FOR THE D412-761-047 KIT.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.01.02
CERT. NO.: SH09-4
ISSUE NO.: 2

A	NEW RELEASE	DB	14.01.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	13	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9681	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL INSTALLATION	NTS
DATE	14.01.02	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Work Order ID 116704

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Page 1

Item ID: D412-761-053 *14/04/20* Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: U/R *[Signature]* Stop ***NS2***
 Item Name: Door Mounted Instrument Panel, LH
 Start Date: 4/23/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/30/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MF Date: 14-4-23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9681	A	<i>fb</i>							
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D412-761-053 chg 001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MLJ 14-08-01